

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022363**Date Inspected:** 31-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Mr. Geng Wei
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

OBG Segment 14E / Bay 14

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as OBG Segment 14E welds as per ZPMC notification # 08691.

The weld designations reviewed are as follows:

DP3165-001-156, 158, 159, 161

DP3166-010~036

DP3165-009~130

OBG Segment 13BE / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 1G position of weld # SEG3009V-058. The welder is identified as 066258. Quality Control (QC) is identified as Wang Xu. The welding variables recorded by QC appeared to comply with WPS- WPS-B-P-2211-TC-U4b-FCM-1.

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OBG Segment 13BE / Bay 14

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of BP 'I' rib weld # SEG3009C-116. The welder is identified as 066733. Quality Control (QC) is identified as Wang Xu. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB. See attached photograph Pic_001.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of SA to AP weld # SEG3019BB-089. The welder is identified as 216086. Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1. See attached photograph Pic_002.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of SA to AP weld # SEG3019BB-133. The welder is identified as 215553. Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of SA to AP weld # SEG3019BB-177. The welder is identified as 054013. Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

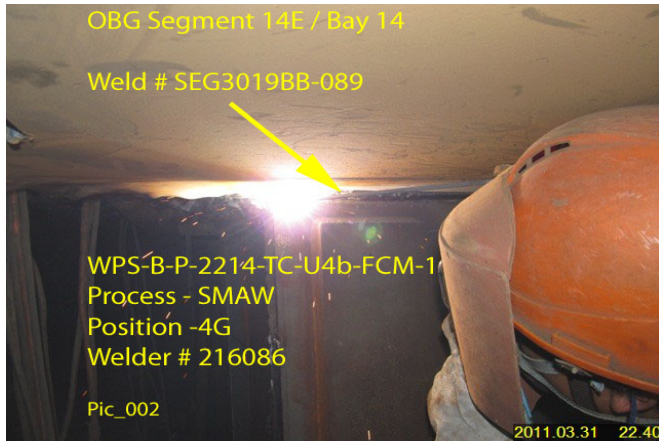
OBG Segment 14E / Bay 14

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of SA to AP weld # SEG3019BB-177. The welder is identified as 054013. Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1.

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Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
